

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018499**Date Inspected:** 29-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-

SEGMENT TAGGING 12CW

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Segment 12CW. The weld designation reviewed is as follows:

DP3062-156 to 166

DP3063-180 to 188,209 to 214

DP3064-221 to 226,261 to 269

DP3065-114 to 119

DP3066-222 to 226,261 to 269

DP3067-72 to 76,103 to 106

DP3068-222 to 226,262 to 269

DP3069-180,181,182,183,210,211,212,213

DP3070-158 to 166

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

BAY#10

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the Tower Façade Plate at 135M, The weld joint was designated as: SD1-SFSA4-502-17. The welder is identified as #057266. ZPMC QC is identified as Mr. Jiang Xiao Bo. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

This QA Inspector observed the following work in progress:

SMAW in the 3F position for the Tower Façade Plate, The weld joint was designated as: SD1-SFSA4-324A/B-15. The welder is identified as #057220. ZPMC QC is identified as Mr. Jiang Xiao Bo. The welding variables recorded by QC appear to comply with WPS-B-P-2113. Please see the attached picture.

BAY#11

This QA Inspector observed the following work in progress:

FCAW in the 1G position for the Tower Lift 6 Component, The weld joint was designated as: WSD1-FGSA6-4-26B. The welder is identified as #053316. ZPMC CWI is identified as Mr. Xu Le Feng. The welding variables recorded by QC appear to comply with WPS-B-T-2231-B-U3-F-2. Please see the attached picture.

This QA Inspector observed the following work in progress:

FCAW in the 1G position for the OBG Bike Path, The weld joint was designated as: BK005A3-003-002. The welder is identified as #040704. ZPMC QC is identified as Mr. Shao hai lang. The welding variables recorded by QC appear to comply with WPS-B-T-2231-TC-U4C-F.

This QA Inspector observed the following work in progress:

FCAW in the 1G position for the OBG Bike Path, The weld joint was designated as: BK005A3-003-010. The welder is identified as #040723. ZPMC QC is identified as Mr. Shao hai lang. The welding variables recorded by QC appear to comply with WPS-B-T-2231-TC-U4C-F.

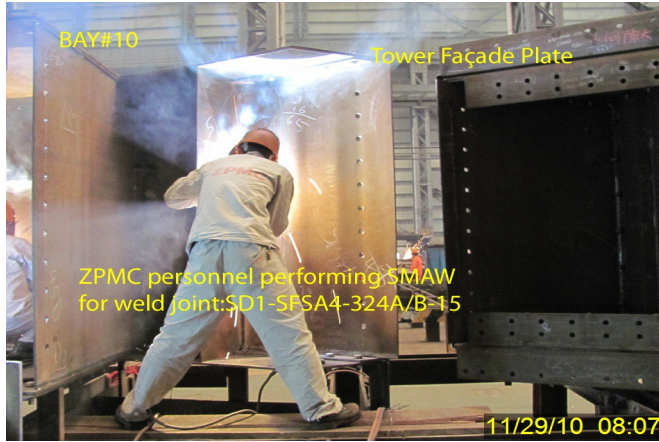
This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Bike Path, The weld joint was designated as: BK004ASD1-022-009/010. The welder is identified as #205649. ZPMC QC is identified as Mr. Shao hai lang. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho -15002048250, who represents the Office of Structural Materials for your project.

Inspected By: Pillai,Pandaram

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer